



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW1805G01631-3G-7
Job Sheet 172696-A



Part No: RBW1805G01631-3G-7

Job Qty: 2 ea

Part Name: Installation Base



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 4/26/18

Job Tracking No:

Due Date: 3/12/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBW1805G01631-3G REV 2 IPP REV A 18.02.16 NEW ISSUE FK VERIFY DP
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
120	CNC Lathe	2 pcs	3/12/18	3/12/18	0.00	2.00	MORI SL2500Y		↑
130	QC	2 pcs	3/12/18	3/12/18	0.00	0.00	QC2 Machining-5		DAS
140	CNC Vertical Machining	2 pcs	3/12/18	3/12/18	0.00	2.00	HAAS1-6		54
150	QC	2 pcs	3/12/18	3/12/18	0.00	0.00	QC2 Machining-5		9-89
152	CNC Lathe	2 pcs	3/12/18	3/12/18	0.00	2.00	MORI SL2500Y		VHJ 18/5/13
154	QC	2 pcs	3/12/18	3/12/18	0.00	2.00	QC2 Machining-1		VHJ 18/5/13
160	QC	2 pcs	3/12/18	3/12/18	0.00	0.00	QC8 Machining-5		SA 18-06-03
190	Packaging	2 pcs	3/12/18	3/12/18	0.00	0.00	Packaging3-2		GA163 18-06-04
200	QC21-SA	2 Ea	3/12/18	3/12/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FB926 FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 140 - 1-Machine as per folio FB926 FOLIO REV: _____ DWG REV: _____ 2- Run in Mazak 3-Deburr
154 - 1- Engrave T/N and/or P/N number using Marktronic engraver as per DWG.
190 - IDENTIFY AND STOCK

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.



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TEL.: 1 613 632-5200
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Part Specifications

Specifications could not be found.

Plex 4/26/18 1:06 PM dart.lacelle.linda

Container No: S065604



Part: RBW1805G01631-3G-7

Job No: 172696-A

Serial No/Batch: S064209

Revision: 2

Inspector:

Date: 04/26/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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								QC / QA Coordinator Approval																																																															
Root Cause <table style="width:100%; border: none;"> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">No Re-verification ☐</td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">Operator ☐</td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">Offset/Setup ☐</td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">Supplier ☐</td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">Training ☐</td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">Use for Testing ☐</td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">Poor Information ☐</td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">Rushing ☐</td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">Product Improvement ☐</td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">Process Improvement ☐</td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">Manufacturing Process ☐</td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">Past Due ☐</td> </tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="border: none;">Pressure/Forced ☐</td> <td style="border: none;">Temperature/Cure ☐</td> <td style="border: none;">Power Loss/Surge ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Bending ☐</td> <td style="border: none;">Set-up ☐</td> <td style="border: none;">Folio/Program ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">Centre Not Concentric ☐</td> <td style="border: none;">BOM/Route ☐</td> <td style="border: none;">Grain ☐</td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Cracks ☐</td> <td style="border: none;">Broken/Damage/Defect ☐</td> <td style="border: none;">Weld ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td> <td style="border: none;">Inspection Incomplete/Unqualified ☐</td> <td style="border: none;">Wrong Stock Pulled ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Cuffs ☐</td> <td style="border: none;">Contamination ☐</td> <td style="border: none;">Out of Sequence ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td style="border: none;">Crushing ☐</td> <td style="border: none;">Countersink ☐</td> <td style="border: none;">Off-set ☐</td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td style="border: none;">Heat Treat ☐</td> <td style="border: none;">Cut Too Short ☐</td> <td style="border: none;">Mislabeled ☐</td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td style="border: none;">Wave/Twist in Tube ☐</td> <td style="border: none;">Instructions Incomplete/Unclear ☐</td> <td style="border: none;">Fit/Function ☐</td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td style="border: none;">Marks/Chatter ☐</td> <td style="border: none;">Drill Holes ☐</td> <td style="border: none;">Misaligned/off center ☐</td> <td style="border: none;">Turning Sequence ☐</td> </tr> </table>						Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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RBW1805G01631-3G-7

Job Sheet 172696



Part No: RBW1805G01631-3G-7

Job Qty: 5 ea

Part Name: Installation Base



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 2/28/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG RBW1805G01631-3G REV 2 IPP REV A 18.02.16 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	2/27/18	2/27/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	3 pcs	2/27/18	2/27/18	0.08	3.00	Bandsaw1		
110	QC	3 pcs	2/27/18	2/27/18	0.00	0.00	QC2 Waterjet-1		
120	CNC Lathe	3 pcs	2/27/18	2/27/18	0.00	3.00	MORI SL2500Y		
130	QC	3 pcs	2/27/18	2/27/18	0.00	0.00	QC2 Machining-5		
140	CNC Vertical Machining	3 pcs	2/27/18	2/27/18	0.00	3.00	HAAS1-6		
150	QC	3 pcs	2/27/18	2/27/18	0.00	0.00	QC2 Machining-5		
152	CNC Lathe	3 pcs	2/27/18	2/27/18	0.00	3.00	MORI SL2500Y		
154	QC	3 pcs	2/28/18	2/28/18	0.00	3.00	QC2 Machining-1		
160	QC	3 pcs	2/28/18	2/28/18	0.00	0.00	QC8 Machining-5		
190	Packaging	3 pcs	2/28/18	2/28/18	0.00	0.00	Packaging3-2		
200	QC21-SA	3 Ea	2/28/18	2/28/18	0.00	0.00	QC21		

Part Op 100 - 1- Cut blank to 10.55"

Descriptions: 120 - 1-Machine as per folio FB 926 FOLIO REV: _____ DWG REV: _____ 2-Deburr
 140 - 1-Machine as per folio FB 926 FOLIO REV: _____ DWG REV: _____ 2- Run in Mazak 3-Deburr
 154 - 1- Engrave T/N and/or P/N number using Marktronic engraver as per DWG.
 190 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R5.500	304 SS Round bar 5.500	2.6370 ft (.879 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R5.500	3	0	0



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Container No: S064209



Part: RBW1805G01631-3G-7

Job No: 172696

Serial No/Batch: S064209

Revision: 2

Inspector:

x 2/21/18 12:11 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD		Work Order:	172696
Description: MVA installation tool		Part Number:	RBW1805G01631-3G-7
Inspection Dwg: RBW1805G-01631-3G-7 Rev: 2		Page 1 of 1	

INSPECTION SHEET

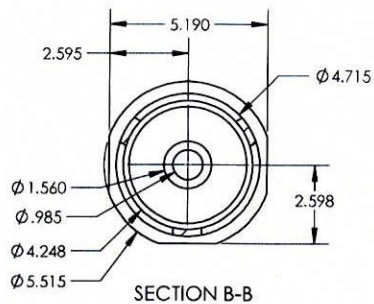
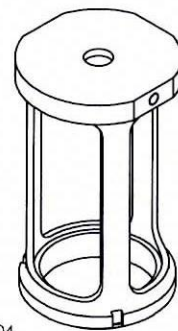
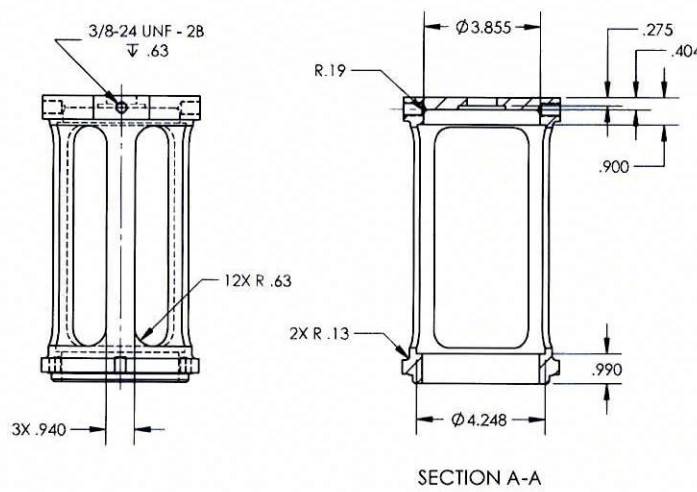
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.353	±.005	0.357	✓			
2.389	±.005	2.386	✓			
Ø5.188	±.005	5.180	✓		CNC-02	
Ø3.865	±.005	3.865	✓		↓	
Ø4.248	±.005	4.248	✓			
9.450	±.005	9.455	✓		↓	
.785	±.005	0.786	✓			
.784	±.005	0.783	✓			
.317	±.005	.320	✓		CNC-02	
1.180	±.005	1.183	✓			
.277	±.005	.280	✓		CNC-02	
.08 x 45°	±.01 x .5°	0.079 x 45°	✓			
5.190	±.005	5.195	✓			
2.595	±.005	2.598	✓			
Ø1.560	±.005	1.560	✓		CNC-02	
Ø.985	±.005	.985	✓		↓	
Ø4.248	±.005	4.248	✓			
Ø5.515	±.005	5.510	✓		↓	
2.598	±.005	2.602	✓			
.990	±.005	0.987	✓			
.393	±.005	0.389	✓			
2.598	±.005	2.599	✓			
7/16-20 UNF	GO - NO GO	7/16-20 UNF	✓			
.63	±.010	0.620	✓			
1.180	±.005	1.183	✓			
Ø4.515	±.005	4.515	✓		CNC-02	
Ø4.765	±.005	4.763	✓		↓	
3/8-24 UNF	GO - NO GO	3/8-24 UNF	✓			
.63	±.010	0.620	✓			

Measured by: <i>[Signature]</i> DAS 54	Checked by:	QC Inspector:
Date: 18-04-20 9-89	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



⑦
INSTALLATION BASE

	
TITLE MVA INSTALLATION TOOL	
DWG NO. RBW1805G01631-3G-7	REV 2
MAT'L S.S. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS & 1/8 .XX ± .01 ANGLES .5° .X ± .01 1. BREAK ALL SHARP EDGES .015 ± .45" OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLAYING	DRAWN BY: SMITH APPROVED: <i>D. West</i> HEAT TREAT FINISH SPEC USED ON MODEL AW139
SCALE 1:4	DATE 4/29/2013
SHEET 5 OF 7	